

Work Order ID 91351

91351

Page 1

October-05-12 9:14:41 AM

Item ID: D3901-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 04/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 19/10/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

12-10-4

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3901

E

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 80.25"

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB090 & dwg D3901,

FOLIO REV: AA

DWG REV: E

2-Deburr as required

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 91351

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Page 2

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N900040100

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Stop ***NS2***

Item Name: Bar

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Cust Item ID:

Required Date: 19/10/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

G.A 12/11/04

6

0

DAS
08
9-89

120

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

130

QC8- Inspect parts - second check

0.00

and 12/11/05

6

0

DAS
14
9-89

130

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

140

Identify as per dwg & Stock Location: W/A

0.00

(56) 27e 12-11-05

140

Packaging

Memo

0.00

Packaging

NCR: Yes / No

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Page 3

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Required Date: 19/10/2012 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/11/6 JH
ML512-11-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

October-05-12 9:14:45 AM

Page 1

Work Order ID: 91351

91351

Parent Item: D3901-5

D3901-5

Parent Item Name: Bar

Start Date: 04/10/2012

Required Date: 19/10/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC
on cnc JFS 12/02/13 verified by:JLM

IPP RevB: Now

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	704.8150	6.648	41.98737			

M304B0 250x0 500

304 BAR .250 x .500

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	704.815	
121216	133.88	
122008	66.87	
122981	0.065	
123216	504	

M123 535 x 42.0

on 12/11/02

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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FAULT CATEGORY				
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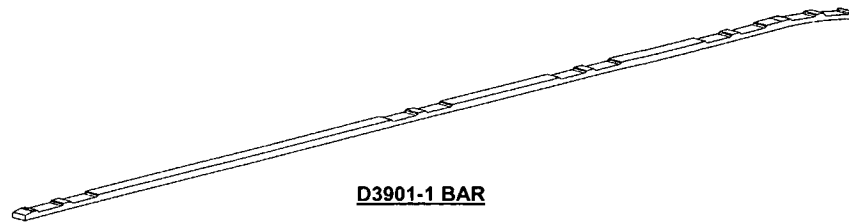
DART AEROSPACE LTD		Work Order:	91351
Description: Bar		Part Number:	D3901-5
Inspection Dwg: D3901 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

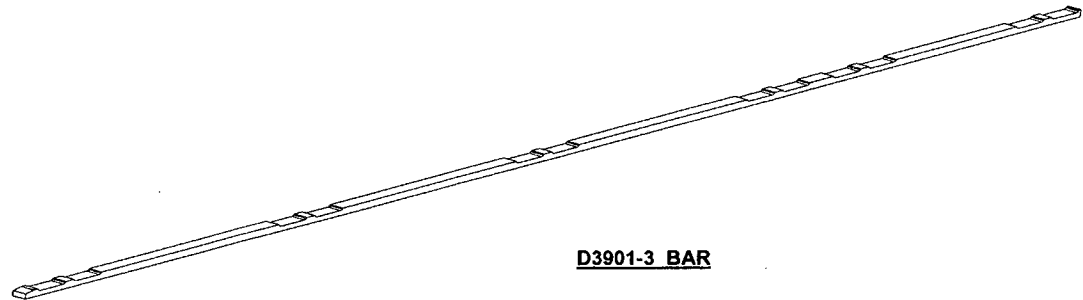
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50 Ref	+/-0.030	0.500	✓		Vern	6A-01
0.25 Ref	+/-0.030	0.249	✓		"	"
4.00	+/-0.030	4.000	✓		"	"
26.00	+/-0.030	25.985	✓		Tape	6A-12
45.62	+/-0.030	46.605	✓		"	"
51.12	+/-0.030	51.105	✓		"	"
61.12	+/-0.030	61.105	✓		"	"
69.62	+/-0.030	69.605	✓		"	"
75.64	+/-0.030	75.625	✓		"	"
0.18	+/-0.030	0.178	✓		Vern	6A-01
0.75	+/-0.030	0.753	✓		"	"
0.50	+/-0.030	0.488	✓		"	"
1.75	+/-0.030	1.755	✓		"	"
0.50	+/-0.030	0.500	✓		"	"

Measured by:	DAS 08 9-89	Audited by:	OK	Preliminary Approval:	
Date:	12/11/04	Date:	12/11/05	Date:	

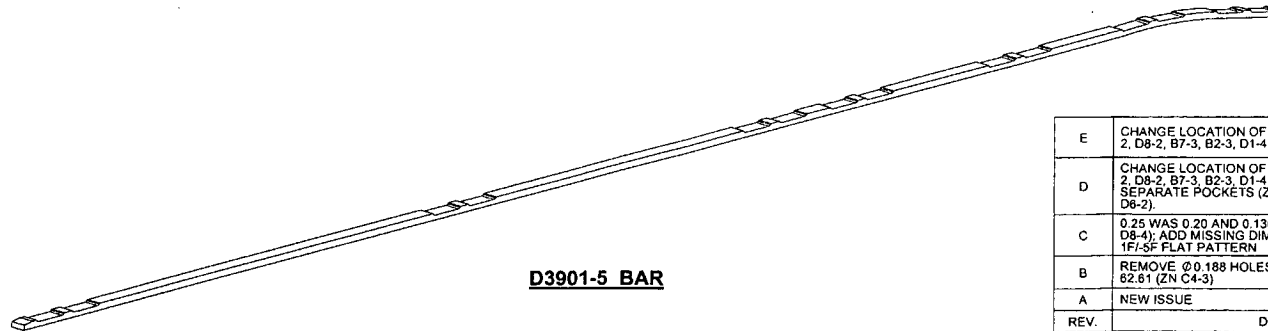
Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	12.07.31	Dimensions updated per Dwg Rev C	KJ	
C	12.09.26	Dimensions updated per Dwg Rev E	KJ	



D3901-1 BAR



D3901-3 BAR

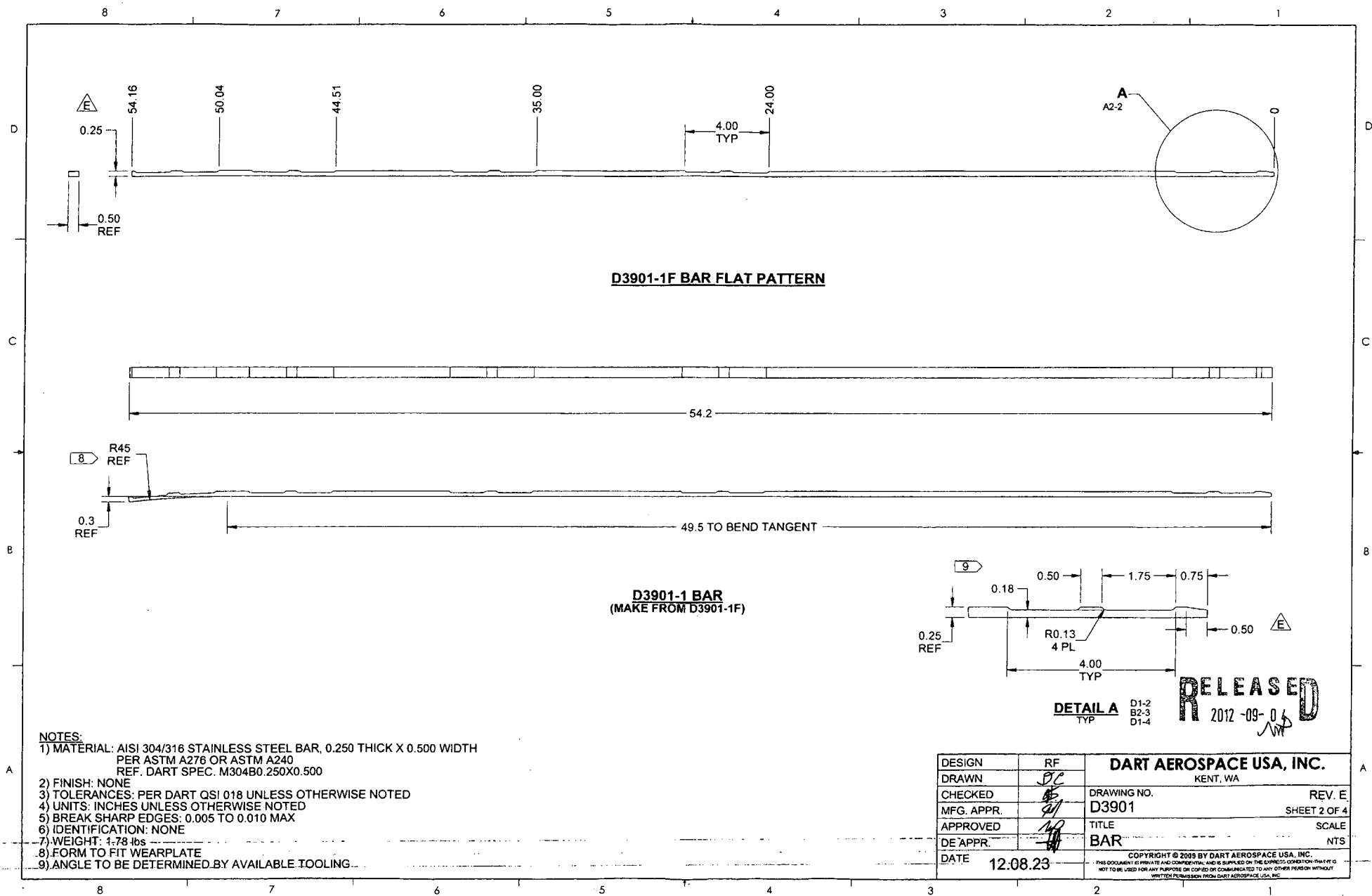


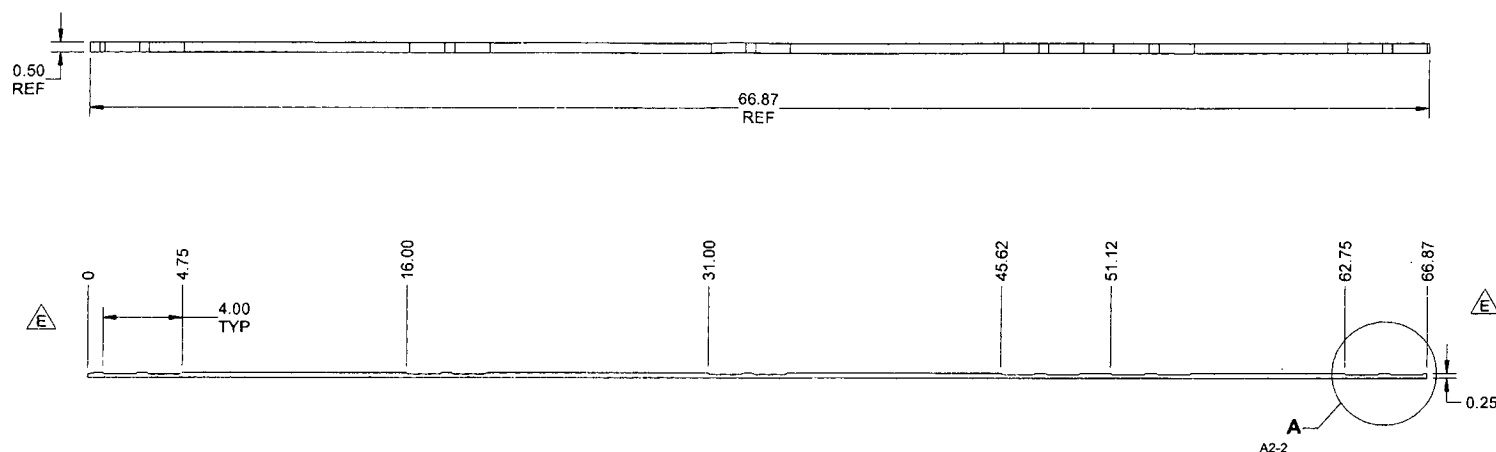
D3901-5 BAR

12-10-4
91351

RELEASED
2012-09-04
MP

E	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN B1-2, D8-2, B7-3, B2-3, D1-4, D7-4).	DC	12.08.23
D	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN D1-2, D8-2, B7-3, B2-3, D1-4, D8-4). SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2). ADD POCKET TO -1 (ZN D6-2).	DC	12.08.21
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F/-5F FLAT PATTERN	RF	12.01.24
B	REMOVE $\varnothing 0.188$ HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	<i>PC</i>	KENT, WA	
CHECKED	<i>PC</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>PC</i>	D3901	SHEET 1 OF 4
APPROVED	<i>PC</i>	TITLE	SCALE
DE APPR.	<i>PC</i>	BAR	NTS
DATE	12.08.23	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





D3901-3 BAR

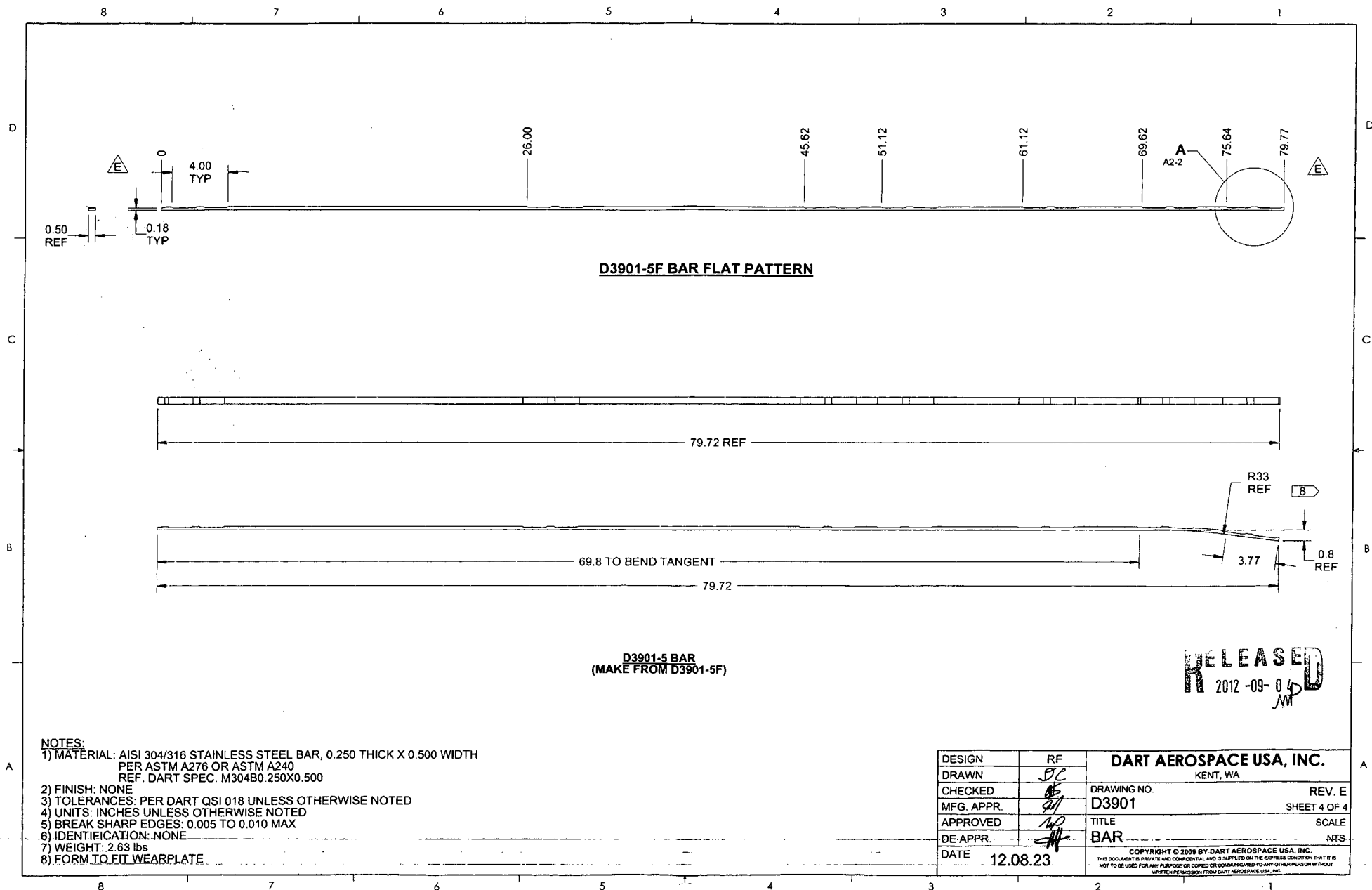
RELEASED
2012-09-04
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.21 lbs

DESIGN		RF		DART AEROSPACE USA, INC.	
DRAWN		BC		KENT, WA	
CHECKED		AS		DRAWING NO. D3901	
MFG. APPR.		21		REV. E	
APPROVED		MP		SHEET 3 OF 4	
DE APPR.		MP		TITLE BAR	
DATE		12.08.23		SCALE NTS	

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RELEASED
 2012-09-05
 JM

